

be covered with a metal jacket of a thickness not less than 11 gauge (0.1196 inch) nominal (Manufacturer's Standard Gauge) and flashed around all openings so as to be weather tight. The exterior surface of a carbon steel tank and the inside surface of a carbon steel jacket must be given a protection coating.

(b) If insulation is a specification requirement, it shall be of sufficient thickness so that the thermal conductance at 60 °F is not more than 0.225 Btu per hour, per square foot, per degree F temperature differential, unless otherwise provided in §179.201-1. If exterior heaters are attached to tank, the thickness of the insulation over each heater element may be reduced to one-half that required for the shell.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and amended by Amdt. 179-10, 36 FR 21349, Nov. 6, 1971; Amdt. 179-50, 60 FR 49078, Sept. 21, 1995]

§ 179.200-6 Thickness of plates.

(a) The wall thickness after forming of the tank shell, dome shell, and of 2:1 ellipsoidal heads must be not less than specified in §179.201-1, nor that calculated by the following formula:

$$t = \frac{Pd}{2SE}$$

Where:

d = Inside diameter in inches;

E = 0.9 Welded joint efficiency; except $E=1.0$ for seamless heads;

P = Minimum required bursting pressure in psig;

S = Minimum tensile strength of plate material in p.s.i. as prescribed in §179.200-7;

t = Minimum thickness of plate in inches after forming.

(b) The wall thickness after forming of 3:1 ellipsoidal heads must be not less than specified in §179.201-1, nor that calculated by the following formula:

$$t = \frac{Pd}{2SE} \times 1.83$$

Where:

d = Inside diameter in inches;

E = 0.9 Welded joint efficiency; except $E=1.0$ for seamless heads;

P = Minimum required bursting pressure in psig;

S = Minimum tensile strength of plate material in p.s.i. as prescribed in §179.200-7;

t = Minimum thickness of plate in inches after forming.

(c) The wall thickness after forming of a flanged and dished head must be not less than specified in §179.201-1, nor that calculated by the following formula:

$$t = \frac{5PL}{6SE}$$

Where:

E = 0.9 Welded joint efficiency; except $E=1.0$ for seamless heads;

L = Main inside radius to which head is dished, measured on concave side in inches;

P = Minimum required bursting pressure in psig;

S = Minimum tensile strength of plate material in p.s.i. as prescribed in §179.200-7;

t = Minimum thickness of plate in inches after forming.

(d) If plates are clad with material having tensile strength properties at least equal to the base plate, the cladding may be considered a part of the base plate when determining thickness. If cladding material does not have tensile strength at least equal to the base plate, the base plate alone must meet the thickness requirements.

(e) For a tank constructed of longitudinal sections, the minimum width of bottom sheet of the tank must be 60 inches measured on the arc, but in all cases the width must be sufficient to bring the entire width of the longitudinal welded joint, including welds, above the bolster.

(f) For a tank built of one piece cylindrical sections, the thickness specified for bottom sheet must apply to the entire cylindrical section.

(g) See §179.200-9 for thickness requirements for a compartmented tank.

[Amdt. 179-10, 36 FR 21349, Nov. 6, 1971, as amended at 66 FR 45390, Aug. 28, 2001]

§ 179.200-7 Materials.

(a) Plate material used to fabricate the tank and, when used, expansion dome or manway nozzle material, must meet one of the following specifications with the indicated minimum tensile strength and elongation in the welded condition.

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(b) *Carbon steel plate*: The maximum allowable carbon content must be 0.31 percent when the individual specification allows carbon content greater than this amount. The plates may be clad with other approved materials:

| Specifications | Minimum tensile strength (p.s.i.) welded condition ¹ | Minimum elongation in 2 inches (percent) weld metal (longitudinal) |
|-------------------------------|---|--|
| AAR TC 128, Gr. B | 81,000 | 19 |
| ASTM A 516 ² | 70,000 | 20 |

¹ Minimum stresses to be used in calculations.

² This specification is incorporated by reference (IBR, see § 171.7 of this subchapter).

(c) *Aluminum alloy plate*: Aluminum alloy plate must be suitable for welding and comply with one of the following specifications (IBR, see § 171.7 of this subchapter):

| Specifications | Minimum tensile strength (p.s.i.) welded condition ^{3 4} | Minimum elongation in 2 inches (percent) 0 temper weld metal (longitudinal) |
|--|---|---|
| ASTM B 209, Alloy 5052 ¹ | 25,000 | 18 |
| ASTM B 209, Alloy 5083 ² | 38,000 | 16 |
| ASTM B 209, Alloy 5086 ¹ | 35,000 | 14 |
| ASTM B 209, Alloy 5154 ¹ | 30,000 | 18 |
| ASTM B 209, Alloy 5254 ¹ | 30,000 | 18 |
| ASTM B 209, Alloy 5454 ¹ | 31,000 | 18 |
| ASTM B 209, Alloy 5652 ¹ | 25,000 | 18 |

¹ For fabrication, the parent plate material may be 0, H112, or H32 temper, but design calculations must be based on minimum tensile strength shown.

² 0 temper only.

³ Weld filler metal 5556 must not be used.

⁴ Maximum stresses to be used in calculations.

(d) *High alloy steel plate*: High alloy steel plate must comply with one of the following specifications:

| Specifications | Minimum tensile strength (p.s.i.) welded condition ¹ | Minimum elongation in 2 inches (percent) weld metal (longitudinal) |
|--|---|--|
| ASTM A 240/A 240M (incorporated by reference; see § 171.7 of this subchapter), Type 304 | 75,000 | 30 |
| ASTM A 240/A 240M (incorporated by reference; see § 171.7 of this subchapter), Type 304L | 70,000 | 30 |
| ASTM A 240/A 240M (incorporated by reference; see § 171.7 of this subchapter), Type 316 | 75,000 | 30 |

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| Specifications | Minimum tensile strength (p.s.i.) welded condition ¹ | Minimum elongation in 2 inches (percent) weld metal (longitudinal) |
|--|---|--|
| ASTM A 240/A 240M (incorporated by reference; see § 171.7 of this subchapter), Type 316L | 70,000 | 30 |

¹ Maximum stresses to be used in calculations.

² High alloy steel materials used to fabricate tank and expansion dome, when used, must be tested in accordance with Practice A of ASTM Specification A 262 titled, "Standard Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels" (IBR; see § 171.7 of this subchapter). If the specimen does not pass Practice A, Practice B or C must be used and the corrosion rates may not exceed the following:

| Test procedure | Material | Corrosion rate i.p.m. |
|------------------|--------------------------------|-----------------------|
| Practice B | Types 304, 304L, 316, and 316L | 0.0040 |
| Practice C | Type 304L | .0020 |

Type 304L and Type 316L test specimens must be given a sensitizing treatment prior to testing. (A typical sensitizing treatment is 1 hour at 1250 F.)

(e) *Nickel plate*: Nickel plate must comply with the following specification (IBR, see § 171.7 of this subchapter):

| Specifications | Minimum tensile strength (psi) welded condition ¹ | Minimum elongation in 2 inches (percent) weld metal (longitudinal) |
|-------------------------------|--|--|
| ASTM B 162 ² | 40,000 | 20 |

(f) *Manganese-molybdenum steel plate*: Manganese-molybdenum steel plate must be suitable for fusion welding and comply with the following specification (IBR, see § 171.7 of this subchapter):

| Specifications | Minimum tensile strength (p.s.i.) welded condition ¹ | Minimum elongation in 2 inches (percent) weld metal (longitudinal) |
|-------------------------|---|--|
| ASTM A 302, Gr. B | 80,000 | 20 |

¹ Maximum stresses to be used in calculations.

(g) All parts and items of construction in contact with the lading must be made of material compatible with plate material and not subject to rapid deterioration by the lading, or be coated or lined with suitable corrosion resistant material.

(h) All external projections that may be in contact with the lading and all

castings, forgings, or fabrications used for fittings or attachments to tank and expansion dome, when used, in contact with lading must be made of material to an approved specification. See AAR Specifications for Tank Cars, appendix M, M4.05 (IBR, see §171.7 of this subchapter) for approved material specifications for castings for fittings.

[Amdt. 179–10, 36 FR 21349, Nov. 9, 1971; 36 FR 21893, Nov. 17, 1971, as amended by Amdt. 179–28, 46 FR 49906, Oct. 8, 1981; Amdt. 179–40, 52 FR 13046, Apr. 20, 1987; Amdt. 179–52, 61 FR 28680, June 5, 1996; 66 FR 45186, Aug. 28, 2001; 67 FR 51660, Aug. 8, 2002; 68 FR 75761, Dec. 31, 2003; 70 FR 34076, June 13, 2005]

§ 179.200–8 Tank heads.

(a) All external tank heads must be an ellipsoid of revolution in which the major axis must equal the diameter of the shell and the minor axis must be one-half the major axis.

(b) Internal compartment tank heads may be 2:1 ellipsoidal, 3:1 ellipsoidal, or flanged and dished to thicknesses as specified in §179.200–6. Flanged and dished heads must have main inside radius not exceeding 10 feet, and inside knuckle radius must not be less than 3¾ inches for steel, alloy steel, or nickel tanks, and not less than 5 inches for aluminum alloy tanks.

[Amdt. 179–10, 36 FR 21350, Nov. 6, 1971]

§ 179.200–9 Compartment tanks.

(a) When a tank is divided into compartments, by inserting interior heads, interior heads must be inserted in accordance with AAR Specifications for Tank Cars, appendix E, E7.00 (IBR, see §171.7 of this subchapter), and must comply with the requirements specified in §179.201–1. Voids between compartment heads must be provided with at least one tapped drain hole at their lowest point, and a tapped hole at the top of the tank. The top hole must be closed, and the bottom hole may be closed, with not less than three-fourths inch and not more than 1½-inch solid pipe plugs having NPT threads.

(b) When the tank is divided into compartments by constructing each compartment as a separate tank, these tanks shall be joined together by a cylinder made of plate, having a thickness not less than that required for the tank shell and applied to the outside surface

of tank head flanges. The cylinder shall fit the straight flange portion of the compartment tank head tightly. The cylinder shall contact the head flange for a distance of at least two times the plate thickness, or a minimum of 1 inch, whichever is greater. The cylinder shall be joined to the head flange by a full fillet weld. Distance from head seam to cylinder shall not be less than 1½ inches or three times the plate thickness, whichever is greater. Voids created by the space between heads of tanks joined together to form a compartment tank shall be provided with a tapped drain hole at their lowest point and a tapped hole at top of tank. The top hole shall be closed and the bottom hole may be closed with solid pipe plugs not less than ¾ inch nor more than 1½ inches having NPT threads.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and amended by Amdt. 179–10, 36 FR 21350, Nov. 6, 1971; 66 FR 45186, Aug. 28, 2001; 68 FR 75761, Dec. 31, 2003]

§ 179.200–10 Welding.

(a) All joints shall be fusion-welded in compliance with the requirements of AAR Specifications for Tank Cars, appendix W (IBR, see §171.7 of this subchapter). Welding procedures, welders and fabricators shall be approved.

(b) Welding is not permitted on or to ductile iron or malleable iron fittings.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and amended by Amdt. 179–10, 36 FR 21350, Nov. 6, 1971; 68 FR 75761, Dec. 31, 2003]

§ 179.200–11 Postweld heat treatment.

When specified in §179.201–1, after welding is complete, postweld heat treatment must be in compliance with the requirements of AAR Specifications for Tank Cars, appendix W (IBR, see §171.7 of this subchapter).

[68 FR 75761, Dec. 31, 2003]

§ 179.200–13 Manway ring or flange, pressure relief device flange, bottom outlet nozzle flange, bottom washout nozzle flange and other attachments and openings.

(a) These attachments shall be fusion welded to the tank and reinforced in an approved manner in compliance with the requirements of appendix E, figure 10, of the AAR Specifications for Tank